



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6795590-4
Job Sheet 197257



Part No: RB6795590-4

Job Qty: 4 pcs

Part Name: Jack Screw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/3/19

Job Tracking No:

Due Date: 8/2/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB6795590 Rev 8 IPP Rev. A 19.06.28 New issue DP Verify DD

Ship Via:

DAS
03
9-59
J

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-154 - 1	4 pcs	8/2/19	8/2/19	1.00	0.80	SL-154 - 1		<i>WSP 19/07/19</i>
110	QC 2	4 pcs	8/2/19	8/2/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		<i>WSP 19/07/19</i>
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S197591



Part: RB6795590-4

Job No: 197257

Serial No/Batch: S197591

Revision: J

Inspector:

Exp Date:

Instructions:

Date: 07/12/19

120 QC 8	4 pcs	8/2/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Outsource - 12 - Black Oxide	4 pcs	8/2/19		GRO002-VC	
140 Packaging 2-1 - Receive - B4B	4 pcs	8/2/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
150 QC 6	4 pcs	8/2/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	

2019-07-12

2019-07-12

JUL 26 2019

DAS
61
0-68

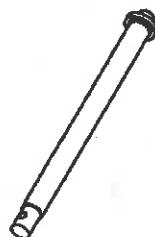
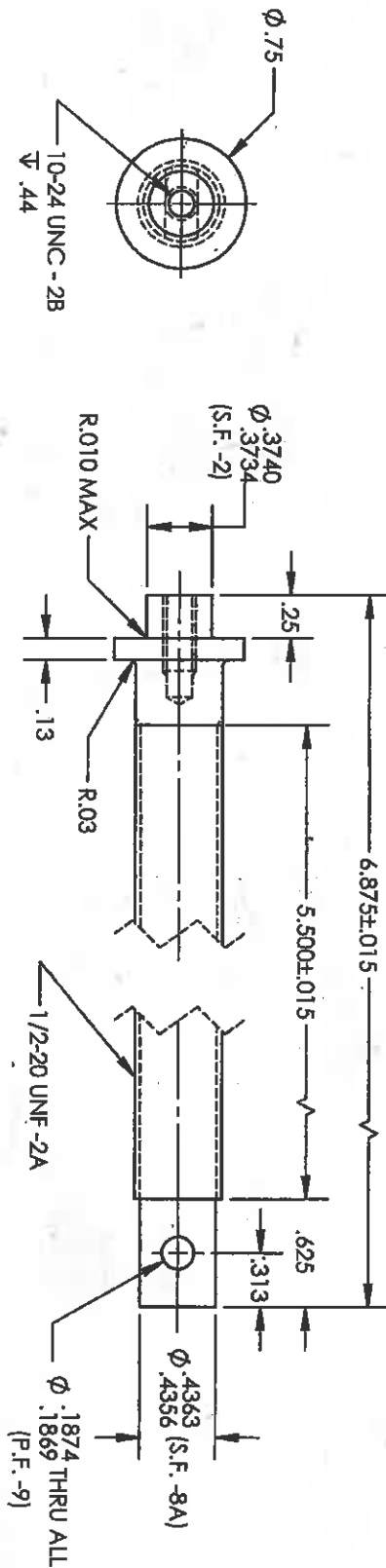
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				QC 6 - 40	
160	Packaging 3-1 - Stock - B4B	4 pcs	8/2/19	0.00	0.00
	Packaging 3 - 1 - B4B				
	Packaging 3 - 2 - B4B				
	Packaging 3 - 3 - B4B				
	Packaging 3 - 4 - B4B				
	Packaging 3 - 5 - B4B				
	Packaging 3 - 6 - B4B				DAS
	Packaging 3 - 7 - B4B				28
	Packaging 3 - 8 - B4B				9-89
	Packaging 3 - 9 - B4B				
	Packaging 3 - 10 - B4B				
	Packaging 3 - 11 - B4B				
	Packaging 3 - 12 - B4B				
	Packaging 3 - 13 - B4B				
	Packaging 3 - 14 - B4B				
	Packaging 3 - 15 - B4B				
	Packaging 3 - 16 - B4B				
	Packaging 3 - 17 - B4B				
	Packaging 3 - 18 - B4B				
	Packaging 3 - 19 - B4B				
	Packaging 3 - 20 - B4B				
	Packaging 3 - 21 - B4B				
	Packaging 3 - 22 - B4B				
	Packaging 3 - 23 - B4B				
	Packaging 3 - 24 - B4B				
	Packaging 3 - 25 - B4B				
	Packaging 3 - 26 - B4B				
170	QC 21 - SA	4 pcs	8/2/19	0.00	0.00
	QC 21 - SA - 21				DAS
	QC 21 - SA - 70				21
	QC 21 - SA - 53				9-89
Part Op 100 - 1-Machine as per folio FC <u>883</u> FOLIO REV: <u>AA</u> DWG REV: <u>J</u> JUL 29 2019 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - -Issue P/O: <u>43994</u> -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required 140 - (Receive & Inspect for Damage & Mat'l Certs) Certificate of Conformity is required 150 - QC6- All purchased or subcontracted products 160 - Identify as per dwg & Stock Location: 170 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MT-4140QT-R0.750	AISI 4140 Quenched & Tempered Steel Round Bar 0.750" Dia.	2.3200 ft (.58 ea)	100-SL-154 - 1	<u>5166278</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-SL-154 - 1	MT-4140QT-R0.750	2	0	0	
Part Specifications					
Specifications could not be found.					

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL APPROVED
7	15-0051	4 CHD DIMS WAS Ø.375 S.F. -2 IS Ø.3734-37.40, WAS Ø.4320-4375 S.F. -8A IS Ø.4356-4363.	3/3/2015	DPD JAG
8	16-0218	4 CHD DIM WAS (Ø.750) IS .75, WAS Ø.3740/.3734 IS Ø.3740/.3734 (S.F. -2), WAS Ø.4363/.4356 IS Ø.4363/.4356 (S.F. -8A), WAS Ø.1874/.1869 THRU ALL (P.F. -9), CHD MATERIAL WAS 4140/4142 Q&T IS 4140/4142, ADDED HEAT TREAT RC 28-34, ADDED FINISH SPEC (QMSI-6.2.2, B.O. REV D).	11/14/2016	RJC SM



DART
AEROSPACE

TITLE BEARING PULLER: GAS PRODUCER
TURBINE, POWER TURBINE & COMPRESSOR

DATE NO. RB6795590-4

MATL 4140/4142	UNLESS OTHERWISE SPECIFIED
FINISH RC 28-34	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	FRACTIONS $\frac{1}{16}$
DRG QMSI-6.2.2, B.O. REV D	ANGLES $\pm .5^\circ$
DRAWN BY: PERRITT	SURFACES $\pm .125$
CHECKED: DUFELDT	1. BREAK ALL SHARP EDGES
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: MACKOVIAK	3. AFTER PLATING AND TOL PER
SCALE 1:1	4. ASSEMBLY DRAWING

(4)

JACK SCREW

APPROVED: MACKOVIAK
DATE 4/11/2008
SHEET 5 OF 11

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality		DEPARTMENT/PROCESS		MRB (QS1042)	
Date : _____		Sequence #: _____		QTY Affected : _____			
Description Work Order Deviation		Disposition					
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread							
Completed By		Lead hand / Supervisor					
QC / QA Coordinator		Other/Details:					

INSPECTION SHEET

Major O-D
M.O.W
wires

Engineering Approval: (If necessary)		Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043994



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3866
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043994

PO Date: 7/12/19

Due Date: 7/22/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-07-16

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	194555	RBE350A94- 2708-01-15	Rod Assembly -Issue P/O: -Black oxide finish, MIL-C- 13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL- PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	7/22/19	12 pcs	0 pcs	12 pcs	\$6.00/pcs	\$72.00
2	197257	RB6795590- 4	Jack Screw -Issue P/O: -Black oxide finish, MIL-C- 13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL- PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	7/22/19	4 pcs	0 pcs	4 pcs	\$6.00/pcs	\$24.00



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PURCHASE ORDER

POHB043994



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	197229	RB T101308-1	Jack Screw -Issue P/O: _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	7/22/19	4 pcs	0 pcs	4 pcs	\$6.00/pcs	\$24.00
Grand Total:											\$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/16/19 8:31 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(020736-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupealtech.com

Bon de Livraison / Packing Slip

020736 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No	Bon de commande Client Customer Purchase Order No.				
25-Jul-2019		Jigar Patel		POHB043994				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	RBE350A94-2708-01-15 Rev.	RBE350A94-2708-01-15 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	12	12	0	0	0
2	RB6795590-4 Rev.	RB6795590-4 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	4	4	0	0	0
3	RBT101308-1 Rev.	RBT101308-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	4	4	0	0	0

RECEIVED

JUL 25 2019

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

 Epaisseur réelle
 Actual Thickness

 Inspecteur Qualité
 Quality Inspector

 Réçu par
 Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.